

Date: Wednesday, 7/16/2008 8:30:58 AM
 User: David Duval

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
 Job Number : 40544
 Estimate Number : 11181
 P.O. Number :
 This Issue : 7/16/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : R & D SM/MED FAB
 Previous Run : 39597
 Written By : 1108/07/16
 Checked & Approved By :
 Comment : Est A 04.08.24 New issue KJ/JLM
 Est Rev:B Now On Waterjet 07-03-26 JLM
 Est Rev:C 08-07-16 Redesign part DD verified by:EC

Part Number : D32941
 Drawing Number : D3294 PROTO
 Project Number : N/A
 Drawing Revision : PROTO
 Material :
 Due Date : 7/23/2008 Qty: 1 Um: Each

Additional Product

PROTOTYPE

Job Number:



FOR THE PERIOD 7/17/08

Seq. #: Machine Or Operation: Description :

1.0 M2024T3S080 2024-T3 .080 sheet



MAT NOT PULLED



Comment: Qty.: 2.1072 sf(s)/Unit Total : 2.1072 sf(s)

Material: 2024-T3 (QC-A-250/4) 0.080" thick

(M2024T3S.080)

Identify for D3294-1

Batch: 108948

HB 8-7-17

good for prototype
1108/07/17

①

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3294

Dwg Rev: PROTO

Prog Rev: PROTO

HB 8-7-17

2-Deburr if necessary

HB 8-7-17

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-7-17



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



1108/07-17 ①



Comment: SECOND CHECK

Process Sheet

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Drawing Name: BRACKET

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Part Number: D32941

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

N/A

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
Form as per Dwg D3294

SS 28/07/23 ①

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING APPROVAL

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat Black Sandtex (Ref. 4.3.5.7) as per QSI 005 4.3

START TIME: _____
OVEN TEMPERATURE: _____
FINISH TIME: _____

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

Ship to Calgary
For Harvey

MF 08-07-24

Date: Wednesday, 7/16/2008 8:30:58 AM
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Process Sheet

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Job Number: 40544

Part Number: D32941

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Change to W/O # 00549

mf 08-07-24



cluttered

Qty 1

Detail Note

~~PROTOTYPE~~

A3294-1 REV B

Default

NOTES:

- 1) MATERIAL:
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "COLOR" (4.3.5.X) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "Default" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: lbs

REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	YY.MM.DD		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	REV. A
TITLE	SHEET 1 OF 2
SCALE	1:1
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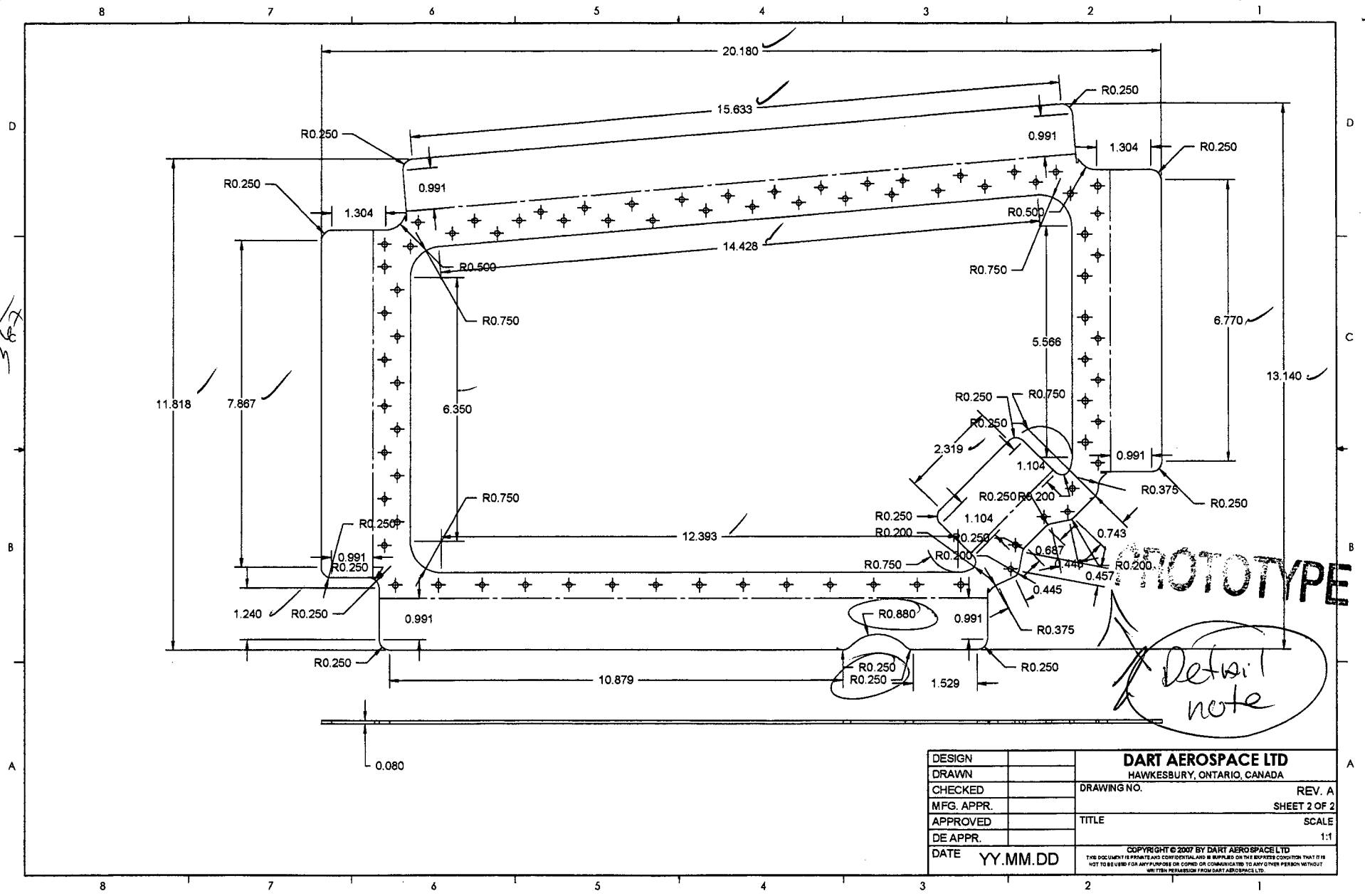
$$\begin{array}{r} 6.77 \\ + 1.50 \\ \hline 8.27 \end{array}$$

$$\begin{array}{r} 2.867 \\ + .50 \\ \hline 3.367 \end{array}$$

$$\begin{array}{r} 15.633 \\ + .50 \\ \hline 16.133 \end{array}$$

$$\begin{array}{r} 7.867 \\ + .50 \\ \hline 8.367 \end{array}$$

$$\begin{array}{r} 1.24 \\ + .06 \\ \hline 1.30 \end{array}$$



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.			1:1
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PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: VERT REF WINDOW

Job #: 00549

Date: 07/15/08

Product Name: D350-567

Requested By: NS

Design Manager Approval: [Signature]

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3294		DOUBLER		N	7/16/08	SHIP TO CAL GARY HARRY	

David Duval

From: Harvey Siemens [hsiemens@dartaero.com]
Sent: Wednesday, July 16, 2008 3:02 PM
To: 'Mike Petsche'
Cc: dduval@dartaero.com
Subject: RE: BRacket

All I want to do is test the shape and size – thinner material thicker material I don't care as long as the shape is correct.

Regards,

Harvey Siemens

Mechanical Designer
DART Aerospace Ltd.

Ph: 403-717-0328
Fax: 403-717-1288
Email: hsiemens@dartaero.com

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: Wednesday, July 16, 2008 12:29 PM
To: 'Harvey Siemens (E-mail)'
Cc: dduval@dartaero.com
Subject: BRacket

Harvey,

David just called me and said that he has an issue with the bracket you requested. He ain't got the material in stock.

Is could you substitute it with something else?

Mike Petsche

Design Manager
DART Aerospace
ph:613-632-5200 ext. 250
mobile: 514-833-1657
Skype: mike.petsche

No virus found in this outgoing message.

Checked by AVG.

Version: 7.5.524 / Virus Database: 270.5.0/1555 - Release Date: 16/07/2008 6:43 AM

7/17/2008